

CH7882

Le A 36 184-US Wim/klu/NT

PROCESS FOR THE RACEMATE RESOLUTION OF 3-AMINOPENTANENITRILE

5

BACKGROUND OF THE INVENTION

Field of the Invention: The present invention relates to a process for the resolution
10 of racemic 3-amino-pentanenitrile with obtainment of enantiomerically enriched
3-aminopentanenitrile or its salts by reaction of racemic 3-aminopentanenitrile
with enantiomerically enriched organic acids.

Brief Description of the Prior Art: (R)-3-Aminopentanenitrile and its salts are
15 important starting materials for the synthesis of pharmaceutical active compounds.
Since the pharmaceutical action is often attributed to only one isomer, it is
desirable to prepare or to make available this desired enantiomer in high optical
purity. The aim is therefore to plan the synthesis such that racemic intermediate
compounds are separated into their enantiomers, in order to obtain homochiral
20 products.

In US-A-4,260,556, the preparation of racemic 3-aminopentanenitrile by reaction
of 2-pentenitrile with ammonia in the presence of a metallic catalyst is
described.

25

In US-A-4,496,474, the reaction of 2-pentenitrile with alkylamines with the
formation of the corresponding racemic cyano compounds is disclosed. In EP-A-
0 449 297, an improved variant of this basic reaction of 2-pentenitrile with
alkylamines in the presence of 15-60% by weight of water is described.

30

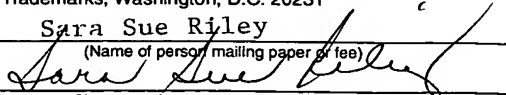
US-A-5,902,883 describes a process for the cyanobutylation of ammonia, alkyl-
amines or hydrazine with 3- and 4-pentenitrile, or mixtures thereof, with
formation of the racemic alkylaminonitriles.

"Express Mail" mailing label number EU942981017US
Date of Deposit October 22, 2003

I hereby certify that this paper or fee is being deposited with the United States
Postal Service "Express Mail Post Office to Addressee" service under 37 CFR
1.10 on the date indicated above and is addressed to the Assistant Commissioner
of Patents and Trademarks, Washington, D.C. 20231

Sara Sue Riley

(Name of person mailing paper or fee)


Signature of person mailing paper or fee)

In the aforementioned prior art, no indication at all of a separation of the racemic mixtures obtained in each case is given.

- 5 In J. Nat. Prod. 65 (2002), 29-31, the preparation of enantiomerically pure (R)- and (S)-3-aminopentanenitrile by constructive synthesis starting from (R)- or (S)-2-amino-butanol is described.

The preparation of enantiomerically pure or enantiomerically enriched (R)- or (S)-
10 3-aminopentanenitrile by resolution of racemic 3-aminopentanenitrile has hitherto not been described anywhere in the prior art.

Since the only method for the synthesis of enantiomerically enriched 3-amino-
pentanenitrile, known from J. Nat. Prod. 65 (2002), 29-31, is very laborious, the
15 object of the present invention consisted in making available a suitable process for the resolution of racemic 3-aminopentanenitrile with enrichment of one of the two enantiomers.

SUMMARY OF THE INVENTION

20 The invention relates to a process for the obtainment of enantiomerically enriched 3-aminopentanenitrile or its salts from racemic 3-aminopentanenitrile by

- 1) reaction of racemic 3-aminopentanenitrile with an enantiomerically
enriched organic acid with formation of two diastereomeric salts of
25 3-aminopentanenitrile and the organic acid,
- 2) separation of one diastereomeric salt from the reaction mixture and
- 3) conversion of this diastereomeric salt into the enantiomerically enriched
3-aminopentanenitrile or its salts.

DETAILED DESCRIPTION OF THE INVENTION

Enantiomerically enriched 3-aminopentanenitrile in the sense of the invention means the enantiomerically pure compounds (R)-3-aminopentanenitrile and (S)-3-aminopentanenitrile or mixtures of the two enantiomers (R)-3-aminopentanenitrile and (S)-3-aminopentanenitrile in which one enantiomer is present in an enantiomeric excess, below also called ee, in comparison with the other enantiomer. Preferably, this enantiomeric excess is 2 to 100% ee, particularly preferably 60% to 100% and very particularly preferably 85 to 100%. A definition of the ee value is indicated in the context of the examples of this application.

Enantiomerically enriched organic acids which can be employed in the sense of this invention are enantiomerically enriched carboxylic acids, enantiomerically enriched sulphonic acids or enantiomerically enriched phosphoric acids.

The use of enantiomerically enriched carboxylic acids is preferred. It is possible in the process according to the invention to employ here, for example:

hydroxycarboxylic acids such as, for example, (L)-(+)-lactic acid, (L)-(-)-malic acid and (L)-(-)-tartaric acid and their derivatives (S)-(-)-phenylcarbamoyllactic acid, (-)-O,O'-dibenzoyl-(L)-tartaric acid and (-)-di-O-p-toluyyl-(L)-tartaric acid, (S)-(+)-mandelic acid and its derivative (S)-methoxyphenylacetic acid, and gulonic acids such as (-)-diacetone-2-keto-L-gulonic acid,

substituted propionic acids such as, for example, (S)-(+)-6-methoxy-2-methyl-2-naphthylacetic acid, (S)-(+)-2-(4-isobutylphenyl)-propionic acid and 2-(2-fluoro-4-biphenyl)-propionic acid,

N-protected amino acid derivatives such as, for example, (L)-N-Boc-alanine, (L)-N-Boc-aspartic acid, (L)-N-Boc-histidine, (L)-N-Boc-isoleucine, (L)-N-Boc-

leucine, (L)-N-Boc-methionine, (L)-N-Boc-phenylalanine, (L)-N-Boc-proline, (L)-N-Boc-serine, (L)-N-Boc-threonine, (L)-N-Boc-tyrosine, (L)-N-Boc-valine and (L)-N-acetyl-leucine,

5 menthol derivatives such as (-)-menthoxyacetic acid or

(S)-(-)-2-pyrrolidinone-5-carboxylic acid.

Analogously, all enantiomers of the specific carboxylic acids mentioned
10 beforehand can also be employed.

In order to obtain (S)-enantiomerically enriched 3-aminopentanenitrile or its salts, the following carboxylic acids are preferably employed in step 1) of the process according to the invention : (S)-methoxyphenylacetic acid, (-)-menthoxyacetic
15 acid and (S)-(-)-2-pyrrolidinone-5-carboxylic acid. (-)-Diacetone-2-keto-L-gulonic acid is particularly preferred. The mother liquor formed in the separation of the diastereomeric salt in step 2) of the process according to the invention can be worked up further and then correspondingly yields the other (R)-enantiomerically enriched 3-aminopentanenitrile or its salts.

20

Preferred carboxylic acids for the obtainment of the (R)-enantiomerically enriched 3-aminopentanenitriles are substituted propionic acids and N-protected amino acid derivatives. (L)-N-Boc-isoleucine and (L)-N-Boc-serine are particularly preferred. The mother liquor formed in the separation of the diastereomeric salt in step 2) of
25 the process according to the invention can be worked up further and then correspondingly yields the (S)-enantiomerically enriched 3-aminopentanenitrile or its salts.

Enantiomerically enriched organic acids of this type such as carboxylic acids, sulphonic acids or phosphoric acid, preferably carboxylic acids, are commercially obtainable. The term "enantiomerically enriched organic acid/carboxylic acid/-sulphonic acid/phosphoric acid" in the sense of this invention means the
5 respective enantiomerically pure organic acids/carboxylic acids/sulphonic acids/phosphoric acids or mixtures of the respective enantiomers in which one enantiomer is present in an enantiomeric excess, below also called ee, in comparison with the other enantiomer. Preferably, this ee value is 10-100%, particularly preferably 60-100% and very particularly preferably 95-100%.

10

The reaction of the racemic 3-aminopentanenitrile with the enantiomerically enriched organic acid with formation of two diastereomeric salts in step 1) of the process according to the invention is expediently carried out in a temperature range from 0°C up to the decomposition temperature of the reactants, preferably in
15 a range from 20 to 120°C. The reaction is particularly preferably carried out in a range from 60 to 80°C.

20

The reaction in step 1) is customarily carried out in the presence of a solvent. The solvents used can be polar or non-polar organic solvents, for example ethers, preferably dialkyl ethers, in particular diethyl ether and *tert*-butyl methyl ether, or cyclic ethers, in particular tetrahydrofuran, straight-chain or branched C₁-C₁₀-alcohols, preferably methanol, ethanol, n-propanol or iso-propanol, straight-chain or branched C₁-C₁₀-alcohol derivatives, such as partly halogenated C₁-C₁₀-alcohols, mononuclear and polynuclear aromatic carbocyclic and heterocyclic
25 hydrocarbons, preferably toluene, aliphatic C₁-C₁₀ hydrocarbons, and functionalized hydrocarbons such as nitriles, for example acetonitrile, carboxylic acid esters, preferably ethyl acetate, ketones and halogen compounds. The amount of the solvent employed is not critical.

The reactants, i.e. the enantiomerically enriched organic acid and the racemic 3-aminopentanenitrile, can be employed in any desired amounts. Preferably, 0.1 - 1 equivalent of the organic acid, particularly preferably approximately 0.5 equivalent of the organic acid, is employed.

5

By means of the reaction of the racemic 3-aminopentanenitrile with the enantiomerically enriched organic acid, two diastereomeric salts of 3-aminopentanenitrile and the organic acid are formed in the process according to the invention. These are, for example, the diastereomeric salts

10

(S)-3-aminopentanenitrile L-(-)-diacetone-2-ketogulonate,

(S)-3-aminopentanenitrile (S)-1-methoxy-1-phenylacetate,

(R)-3-aminopentanenitrile N-Boc-L-isoleucinate,

(R)-3-aminopentanenitrile N-Boc-L-leucinate,

15 (R)-3-aminopentanenitrile N-Boc-L-serinate,

(S)-3-aminopentanenitrile (S)-(-)-2-pyrrolidinone-5-carboxylate,

(R)-3-aminopentanenitrile (S)-(+)-6-methoxy- α -methyl-2-naphthylacetate,

(R)-3-aminopentanenitrile (S)-(+)-2-(4-isobutylphenyl)-propioncarboxylate,

(R)-3-aminopentanenitrile (S)-(-)-O-(phenylcarbamoyl)-lactate,

20 (R)-3-aminopentanenitrile (-)-O,O'-dibenzoyl-L-tartrate,

(R)-3-aminopentanenitrile (-)-di-O-p-toluyyl-L-tartrate,

(S)-3-aminopentanenitrile (-)-menthoxyacetate,

(R)-3-aminopentanenitrile N-acetyl-L-leucinate

and their respective enantiomers.

25

During the reaction in step 1), one of the two diastereomeric salts customarily precipitates in the form of a solid. The separation of this diastereomeric salt from the reaction mixture is customarily carried out in step 2) by filtering off or centrifuging off.

The reaction mixture which remains after filtering off the diastereomeric salt can be worked up if desired to obtain the second diastereomeric salt.

5 In an alternative embodiment of the process according to the invention, it can be expedient to subject the diastereomeric salt separated off as a solid in step 2) to one or more recrystallizations before in step 3) of the process the enantiomerically enriched 3-aminopentanenitrile or its salts are obtained. For these recrystallizations, the use of the solvents already mentioned in step 1) has proved
10 suitable.

In step 3), the desired enantiomerically enriched 3-aminopentanenitrile or its salts are then obtained from the separated-off diastereomeric salt of the desired enantiomerically enriched 3-aminopentanenitrile or its salts. This can take place
15 by chemical means.

For this, the diastereomeric salt is reacted with a base which is stronger than the amine function in 3-aminopentanenitrile, e.g. with alkali metal hydroxides, alkaline earth metal hydroxides, preferably sodium hydroxide or potassium
20 hydroxide, alkali metal carbonates or alkaline earth metal carbonates, preferably sodium carbonate or potassium carbonate, and subsequently extracted with an organic solvent. The solvents employed can be the organic solvents already mentioned previously. Expediently, 1-5 N solutions of the base at a temperature of 0 to 100°C are employed. The use of 1N sodium hydroxide solution at a
25 temperature of 15 to 40°C with subsequent extraction by dichloromethane is particularly preferred. During this reaction of the diastereomeric salt with a base, the enantiomerically enriched 3-aminopentanenitrile is obtained as such, i.e. as the free base.

Alternatively to this, the diastereomeric salt can also be reacted in an organic solvent with a strong acid which is stronger than the enantiomerically enriched organic acid employed in step 1). In this connection, for example, hydrochloric acid, hydriodic acid, hydrobromic acid, hydrofluoric acid, sulphuric acid, nitric acid, perchloric acid, phosphoric acid or methanesulphonic acid is employed.

Hydrochloric acid, hydrobromic acid, sulphuric acid and methanesulphonic acid are preferred. This reaction in step 3) is carried out at a temperature in the range from 0°C up to approximately the decomposition temperature of the reactants, preferably in a range from 20 to 150°C and particularly preferably in a range from 40 to 90°C. The solvents employed can be the organic solvents already mentioned previously. Preferably, ethers, particularly preferably *tert*-butyl methyl ether, are employed as solvents. In this variant, the desired enantiomerically enriched 3-aminopentanenitrile is obtained directly as the salt of the strong acid. The following salts of 3-aminopentanenitrile are obtained, for example:

- enantiomerically enriched 3-aminopentanenitrile fluoride
- enantiomerically enriched 3-aminopentanenitrile chloride
- enantiomerically enriched 3-aminopentanenitrile bromide
- enantiomerically enriched 3-aminopentanenitrile iodide
- enantiomerically enriched 3-aminopentanenitrile sulphate
- enantiomerically enriched 3-aminopentanenitrile hydrogensulphate
- enantiomerically enriched 3-aminopentanenitrile phosphate
- enantiomerically enriched 3-aminopentanenitrile hydrogenphosphate
- enantiomerically enriched 3-aminopentanenitrile dihydrogenphosphate
- enantiomerically enriched 3-aminopentanenitrile nitrate
- enantiomerically enriched 3-aminopentanenitrile perchlorate.

The salts can be used for the preparation of pharmaceutical active compounds.

Examples:

In all examples below, the optical purity of the (R)-or (S)-3-aminopentanenitrile is determined by gas chromatography on a chiral column material (gamma-Dex 225) and indicated by means of the ee ("enantiomeric excess") (S) or (R) value defined below.

The ee value is given here by means of the following formulae:

$$ee(S) = \frac{m(S)-m(R)}{m(S+R)} \times 100\%$$

$$ee(R) = \frac{m(R)-m(S)}{m(S+R)} \times 100\%$$

where ee (S) or ee (R) is the optical purity of the enantiomer S or R, m(S) is the amount of substance of the enantiomer S and m(R) is the amount of substance of the enantiomer R. (Examples: for a racemate: R=S => ee = 0; for the pure (S) form: ee (S) = 100%; for a ratio of S:R = 9:1, ee (S) = 80%)

Example 1:**Racemate resolution using (-)-diacetone-2-keto-L-gulonic acid**

1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in the amount of the respective solvent indicated in Table 1a. 1.77 g (7.65 mmol) of (-)-diacetone-2-keto-L-gulonic acid are added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product formed as a solid is filtered off and dried at 40°C under reduced pressure for 10 hours. The product is then dissolved in 20 ml of 1N sodium hydroxide solution. The aqueous

phase is extracted twice with 10 ml each time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure. The yields and ee values achieved are indicated in Table 1a.

5 **Table 1a**

Solvent	EtOH	Toluene	MTBE	EtOAc	CH ₃ CN	MeOH
Amount (ml)	60	75	90	40	75	45
ee (S) (%)	69.5	35.2	17.6	38.6	42.8	57.3
Yield (%)	33.4	40.0	56.0	37.0	37.0	31.0

EtOH = ethanol, MTBE = methyl tert-butyl ether, EtOAc = ethyl acetate, MeOH= methanol

10

Example 1 b

By reaction of racemic 3-aminopentanenitrile with (-)-diacetone-2-keto-L-gulonic acid in analogy to Example 1 in ethanol as a solvent, a precipitate of the diastereomeric salt is obtained. This is subjected to a further recrystallization, whereby the optical purity and thus the ee value of the (S)-enantiomerically enriched 3-aminopentanenitrile can be further increased. The ee(S) value of the diastereomeric salt employed for the recrystallization is, after an extraction carried out in analogy to Example 1, 59.6.

20

For the recrystallization, 1.5 g of the diastereomeric salt are dissolved at boiling temperature in the amount of the respective solvent in each case indicated in Table 1b. The further work-up of the salt precipitating on cooling is carried out as described for Example 1.

25

Table 1b

Solvent	EtOH	CH ₃ CN	Toluene	MTBE	EtOAc	MeOH
Amount (ml)	40	40	50	40	50	35
ee (S) (%)	67.8	65.6	61.5	61.3	64.2	82.4
Yield (%)	93.3	94.7	98.0	98.7	94.4	68.0

Example 2:5 **Racemate resolution using (S)-methoxyphenylacetic acid**

1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in the amount of the respective solvent indicated in Table 2. 1.27 g (7.64 mmol) of (S)-methoxyphenylacetic acid are added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product forming as a solid is filtered off and dried at 40°C under reduced pressure for 10 hours. The product is then dissolved in 20 ml of 1N sodium hydroxide solution. The aqueous phase is extracted twice with 10 ml each time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure .

15

The yields and ee values achieved are indicated in Table 2.

Table 2

Solvent	EtOH	Toluene	MTBE	EtOAc	CH ₃ CN	MeOH
Amount (ml)	60	40	45	30	15	15
ee (S) (%)	50.7	54.7	55.8	49.7	71.6	81.6
Yield (%)	40.0	28.0	3.0	31.0	53.0	15.0

20

Example 3:

Racemate resolution using (S)-(+)-6-methoxy- α -methyl-2-naphthylacetic acid

1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in 10 ml of ethanol.

- 5 1.76 g (7.64 mmol) of (S)-(+)-6-methoxy- α -methyl-2-naphthylacetic acid are added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product forming as a solid is filtered off and dried at 40°C under reduced pressure for 10 hours. The product is then dissolved in 20 ml of 1N sodium hydroxide solution. The aqueous phase is extracted twice
10 with 10 ml each time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure.

0.60 g (40.0%) of (R)-3-aminopentanenitrile is obtained as a colourless liquid. The ee (R) value is 27.4%.

15

Example 4:

Racemate resolution using (S)-(+)-2-(4-isobutylphenyl)propionic acid

1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in 10 ml of ethanol.

- 20 1.58 g (7.64 mmol) of (S)-(+)-2-(4-isobutylphenyl)-propionic acid are added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product forming as a solid is filtered off and dried at 40°C under reduced pressure for 10 hours. The product is then dissolved in 20 ml of 1N sodium hydroxide solution. The aqueous phase is extracted twice with
25 10 ml each time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure.

0.78 g (52.0%) of (R)-3-aminopentanenitrile is obtained as a colourless liquid. The ee(R) value is 2.4%.

Example 5:**Racemate resolution using (L)-N-Boc-isoleucine**

5 1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in the amount of solvent used indicated in Table 3a. 1.77 g (7.64 mmol) of (L)-N-Boc-isoleucine are added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product forming as a solid is filtered off and dried at 40°C under reduced pressure for 10 hours. The product is then dissolved
10 in 20 ml of 1N sodium hydroxide solution. The aqueous phase is extracted twice with 10 ml each time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure .

The yields and ee values achieved are indicated in Table 3a.

15

Table 3a

Solvent	EtOH	Toluene	MTBE	EtOAc	CH ₃ CN
Amount (ml)	10	15	15	15	15
ee (R) (%)	92.2	68.7	85.7	81.4	82.5
Yield (%)	6.7	42.0	35.0	36.0	29.0

Example 5b:

20

By reaction of racemic 3-aminopentanenitrile with (L)-N-Boc-isoleucine in analogy to Example 5 in ethanol as a solvent, a precipitate of the diastereomeric salt is obtained. This is subjected to a further recrystallization, whereby the optical purity and thus the ee value of the (R)-enantiomerically enriched 3-

25 aminopentanenitrile can be further increased. The ee(R) value of the

diastereomeric salt employed for the recrystallization is, after an extraction carried out in analogy to Example 5, 90.4.

For the recrystallization, 1.25 g of the diastereomeric salt are dissolved at boiling temperature in the amount of the respective solvent indicated in Table 3b. The further work-up of the salt precipitating on cooling is carried out as described for Example 5.

Table 3b

Solvent	EtOH	CH ₃ CN	Toluene	MTBE	EtOAc	MeOH
Amount (ml)	4	10	5	45	5	2
ee (R) (%)	98.5	98.3	95.3	98.7	96.8	98.0
Yield (%)	34.9	32.2	80.6	69.8	56.4	29.5

Example 6:

Racemate resolution using (L)-N-Boc-isoleucine with subsequent precipitation of the enantiomerically enriched 3-aminopentanenitrile methanesulphonate

33.05 g (336.7 mmol) of 3-aminopentanenitrile are dissolved in 830 ml of *tert*-butyl methyl ether. 39.0 g (168.6 mmol) of (L)-N-Boc-isoleucine are added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product forming as a solid is filtered off and washed twice with 50 ml each time of *tert*-butyl methyl ether. The product is recrystallized once from 1650 ml of *tert*-butyl methyl ether. After cooling to 20°C, the solid is filtered off with suction and washed twice with 50 ml of *tert*-butyl methyl ether.

35.0 g of a colourless solid are obtained.

This is suspended in 700 ml of *tert*-butyl methyl ether. 10.22 g (106.3 mmol) of methanesulphonic acid are then added dropwise to this suspension. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the solid is filtered off with suction, washed twice with 25 ml each time of *tert*-butyl methyl ether and dried under reduced pressure at 50°C for 10 hours.

19.8 g (30.3%) of (R)-3-aminopentanenitrile methanesulphonate are obtained as a colourless solid.

For the determination of the optical purity, 1 g of the product obtained is dissolved in 20 ml of 1N sodium hydroxide solution and the solution is extracted twice with 10 ml each of dichloromethane. After removing the solvent under reduced pressure, the ee value is determined from the residue by gas chromatography. The ee (R) value is 99.0%.

NMR (400 MHz, D₂O): (ppm) = 1.00 (t, J = 7.5 Hz, 3H), 1.83 (dt, J = 7.3 / 7.3 Hz, 2H), 2.80 (s, 3H), 3.02 (d, J = 5.3 Hz, 2H), 3.63 (tt, J = 6.3 / 6.3 Hz, 1H), 4.75 (s, 3H).

Melting range: 109-111°C

Elemental analysis:	calc.: C = 37.11	found.: C = 37.3
	calc.: H = 7.27	found.: H = 7.4
	calc.: N = 14.42	found.: N = 14.1
	calc.: S = 16.48	found.: S = 16.4

Example 7:

Racemate resolution using (L)-N-Boc-serine

1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in the amount of solvent used indicated in Table 4. 1.57 g (7.64 mmol) of (L)-N-Boc-serine are added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product forming as a solid is filtered off and dried at 40°C under reduced pressure for 10 hours. The product is then dissolved in 20 ml of 1N sodium hydroxide solution. The aqueous phase is extracted twice with 10 ml each time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure.

The yields and ee values achieved are indicated in Table 4.

Table 4

Solvent	EtOH	Toluene	MTBE	EtOAc	CH ₃ CN	MeOH
Amount (ml)	10	60	30	60	60	8
ee (R) (%)	70.0	70.7	76.0	80.4	63.3	86.8
Yield (%)	29.3	26.0	43.0	30.0	32.0	55.0

Example 8:

Racemate resolution using (S)-(-)-phenylcarbamoyllactic acid

1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in 10 ml of ethanol.

1.60 g (7.64 mmol) of (S)-(-)-phenylcarbamoyllactic acid are added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product forming as a solid is filtered off and dried at 40°C under reduced pressure for 10 hours. The product is then dissolved in 20 ml of 1N sodium hydroxide solution. The aqueous phase is extracted twice with 10 ml each

time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure.

0.16 g (10.6%) of (R)-3-aminopentanenitrile is obtained as a colourless liquid. The
5 ee (R) value is 23.1%.

Example 9:

Racemate resolution using (-)-O,O'-dibenzoyl-(L)-tartaric acid

10 1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in 20 ml of ethanol.
2.74 g (7.64 mmol) of (-)-O,O'-dibenzoyl-(L)-tartaric acid are added to this
solution in one portion. The suspension is heated to boiling for 5 minutes. After
cooling to 20°C, the product forming as a solid is filtered off and dried at 40°C
under reduced pressure for 10 hours. The product is then dissolved in 20 ml of 1N
15 sodium hydroxide solution. The aqueous phase is extracted twice with 10 ml each
of dichloromethane. The solvent of the combined organic phases is distilled off
under reduced pressure.

0.84 g (56.0%) of (R)-3-aminopentanenitrile is obtained as a colourless liquid. The
20 ee (R) value is 4.4%.

Example 10:

Racemate resolution using (-)-di-O-p-toluyyl-(L)-tartaric acid

25 1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in 15 ml of ethanol.
2.95 g (7.64 mmol) of (-)-di-O-p-toluyyl-(L)-tartaric acid are added to this solution
in one portion. The suspension is heated to boiling for 5 minutes. After cooling to
20°C, the product forming as a solid is filtered off and dried at 40°C under
reduced pressure for 10 hours. The product is then dissolved in 20 ml of 1N

sodium hydroxide solution. The aqueous phase is extracted twice with 10 ml each time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure.

- 5 1.04 g (69.3%) of (R)-3-aminopentanenitrile are obtained as a colourless liquid. The ee (R) value is 17.4%.

Example 11:

Racemate resolution using (-)-menthoxyacetic acid

'10

- 1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in 10 ml of ethanol. 1.64 g (7.64 mmol) of (-)-menthoxyacetic acid are added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product forming as a solid is filtered off and dried at 40°C under reduced
15 pressure for 10 hours. The product is then dissolved in 20 ml of 1N sodium hydroxide solution. The aqueous phase is extracted twice with 10 ml each time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure.
- 20 0.30 g (20.0%) of (S)-3-aminopentanenitrile is obtained as a colourless liquid. The ee (S) value is 55.2%.

Example 12:

Racemate resolution using (S)-(-)-2-pyrrolidinone-5-carboxylic acid

25

1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in the amount of solvent used indicated in Table 5. 0.99 g (7.6 mmol) of (S)-(-)-2-pyrrolidinone-5-carboxylic acid is added to this solution in one portion. The suspension is heated to boiling for 5 minutes. After cooling to 20°C, the product forming as a solid is

filtered off and dried at 40°C under reduced pressure for 10 hours. The product is then dissolved in 20 ml of 1N sodium hydroxide solution. The aqueous phase is extracted twice with 10 ml each time of dichloromethane. The solvent of the combined organic phases is distilled off under reduced pressure.

5

The yields and ee values achieved are indicated in Table 5.

Table 5

Solvent	EtOH	MTBE	EtOAc	CH ₃ CN
Amount (ml)	15	15	15	15
ee (S) (%)	55.2	39.0	35.9	26.3
Yield (%)	29.3	43.0	30.0	32.0

10

Example 13:

Racemate resolution using N-acetyl-(L)-leucine

1.50 g (15.3 mmol) of 3-aminopentanenitrile are dissolved in the amount of
15 solvent used indicated in Table 6a. 1.32 g (7.64 mmol) of N-Acetyl-(L)-leucine
are added to this solution in one portion. The suspension is heated to boiling for 5
minutes. After cooling to 20°C, the product forming as a solid is filtered off and
dried at 40°C under reduced pressure for 10 hours. The product is then dissolved
20 in 20 ml of 1N sodium hydroxide solution. The aqueous phase is extracted twice
with 10 ml each time of dichloromethane. The solvent of the combined organic
phases is distilled off under reduced pressure.

The yields and ee values achieved are indicated in Table 6a.

Table 6a

Solvent	EtOH	Toluene	MTBE	EtOAc	CH ₃ CN	MeOH
Amount (ml)	15	25	25	25	25	15
ee (R) (%)	66.4	46.7	50.7	42.4	41.2	71.1
Yield (%)	46.0	47.0	50.0	48.0	45.0	25.0

Example 13b:

5

By reaction of racemic 3-aminopentanenitrile with N-acetyl-(L)-leucine in analogy to Example 13 in ethanol as a solvent, a precipitate of the diastereomeric salt is obtained. This is subjected to a further recrystallization, whereby the optical purity and thus the ee value of the (R)-enantiomerically enriched 3-aminopentanenitrile can be further increased. The ee(R) value of the diastereomeric salt employed for the recrystallization, after an extraction carried out in analogy to Example 13, is 56.0.

10

For the recrystallization, 1.2 g of diastereomeric salt are dissolved at boiling temperature in the respective amount of solvent in each case indicated in Table 6b. The further work-up of the salt precipitating on cooling is carried out as described for Example 13.

15

Table 6b

20

Solvent	EtOH	CH ₃ CN	MeOH
Amount (ml)	20	60	8
ee (R) (%)	78.8	65.3	87.4
Yield (%)	50.7	62.2	36.9

Although the invention has been described in detail in the foregoing for the purpose of illustration, it is to be understood that such detail is solely for that purpose and that variations can be made therein by those skilled in the art without departing from the spirit and scope of the invention except as it may be limited by
5 the claims.